

B/N incorrect engined on Dart Aerospace Ltd.

Saddles - S/B 27059 - File under  
Process Sheet D2573 / 74

Date: Thursday, 5/11/2006 11:52:16 AM  
User: Kim Johnston

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	27059	Part Number	: D2574		
Estimate Number	10534	Drawing Number	: D2574 REV E		
P.O. Number	N/A	Project Number	: N/A		
This Issue	5/11/2006	S.O. No.	: N/A		
Prsht Rev.	NC	Type	: MACHINED PARTS		
First Issue	N/A	Material	: N/A		
Previous Run	26975	Due Date	5/30/2006	Qty:	16
Written By	See comment below				
Checked & Approved By	06.05.11				
Comment	Est Rev: 1 As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2574 Ensure that grain is along 5.00" length Batch No: B 28940 x 16</p> <p>Ep / J.G 06/07/02</p>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	

Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. B27057 Double check by: JL

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove sharp edges.

Ep / J.G 06/07/02

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
<p>Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 &amp; D2574</p> <p>Ep / J.G 06/07/02</p>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p>Ep / J.G 06/07/02</p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 27059		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/06/26	2.0	wrong Batch # Kept in. operator error 2 parts effected	<i>AB</i> <i>ABCD</i>	Change Batch # right away tell operator to PAY more attention 2 parts Identical with B27058 D2574.	<i>AB</i> <i>AB</i>	<i>AB</i>	<i>AB</i>	<i>AB</i>

Part No: D2574 PAR #: P/A Fault Category: Prog - CNC NCR:  Yes  No DQA: AB Date: 06.07.20  
 NOTE: Date & initial all entries QA: N/C Closed: AB Date: 06.07.20

Date: Thursday, 5/11/2006 11:52:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 27059

Part Number: D2574

Job Number:



Seq. #: Machine Or Operation:

Description: ○

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

ML 06/07/04 16

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am 06-07-04

Q

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/18 (6)

DL

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PL 06/07/18 (16)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57352

PL 06/07/18 (16)

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.20

Job Completion:



W 06.07.19

NOTE: Date: 11/05/2006 AssurenceApp  
H.100MS Quality Assurance App

Dart Aerospace  
W/0

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_

PAR #: \_\_\_\_\_

Fault Category: \_\_\_\_\_

NCR: Yes No DQA: \_\_\_\_\_

Date: \_\_\_\_\_

&amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD			Work Order:	27059
Description: Saddle, Aft Inboard			Part Number:	D2574
Inspection Dwg: D2574 Rev. E			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.441	0.441		
B	1.745	1.755		1.748	1.747	1.746	1.747		
C	3.495	3.505		3.499	3.497	3.497	3.498		
D	1.745	1.755		1.748	1.747	1.746	1.747		
E	7.990	8.010		8.006	8.006	8.007	8.003		
F	0.490	0.510		0.499	0.499	0.501	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.374	0.374	0.377	0.377		
I	0.490	0.510		0.498	0.496	0.495	0.494		
J	1.174	1.184		1.178	1.178	1.179	1.178		
K	0.558	0.578		0.561	0.565	0.565	0.568		
L	1.174	1.184		1.178	1.178	1.179	1.178		
M	1.365	1.375		1.367	1.369	1.366	1.367		
N	2.495	2.505		2.498	2.497	2.497	2.497		
O	4.119	4.129		4.123	4.119	4.122	4.121		
P	0.115	0.135		0.123	0.124	0.122	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.249	0.249	0.251	0.252		
S	0.115	0.135		0.119	0.118	0.120	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.235	0.240	0.237	0.239		
W	0.115	0.135		0.121	0.126	0.125	0.127		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.359	0.361	0.361	0.367		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.623	0.622	0.623	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.245	0.246	0.244		
AE	1.500	1.520		1.572	1.572	1.571	1.508		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.248	0.246	0.249		
AI	2.000	2.020		2.04	2.04	2.04	2.04		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EP / J.G	Audited by:	JMK
Date:	06/06/127	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JMK

DART AEROSPACE LTD				Work Order: 27059	
Description: Saddle, Aft Inboard				Part Number: D2574	
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

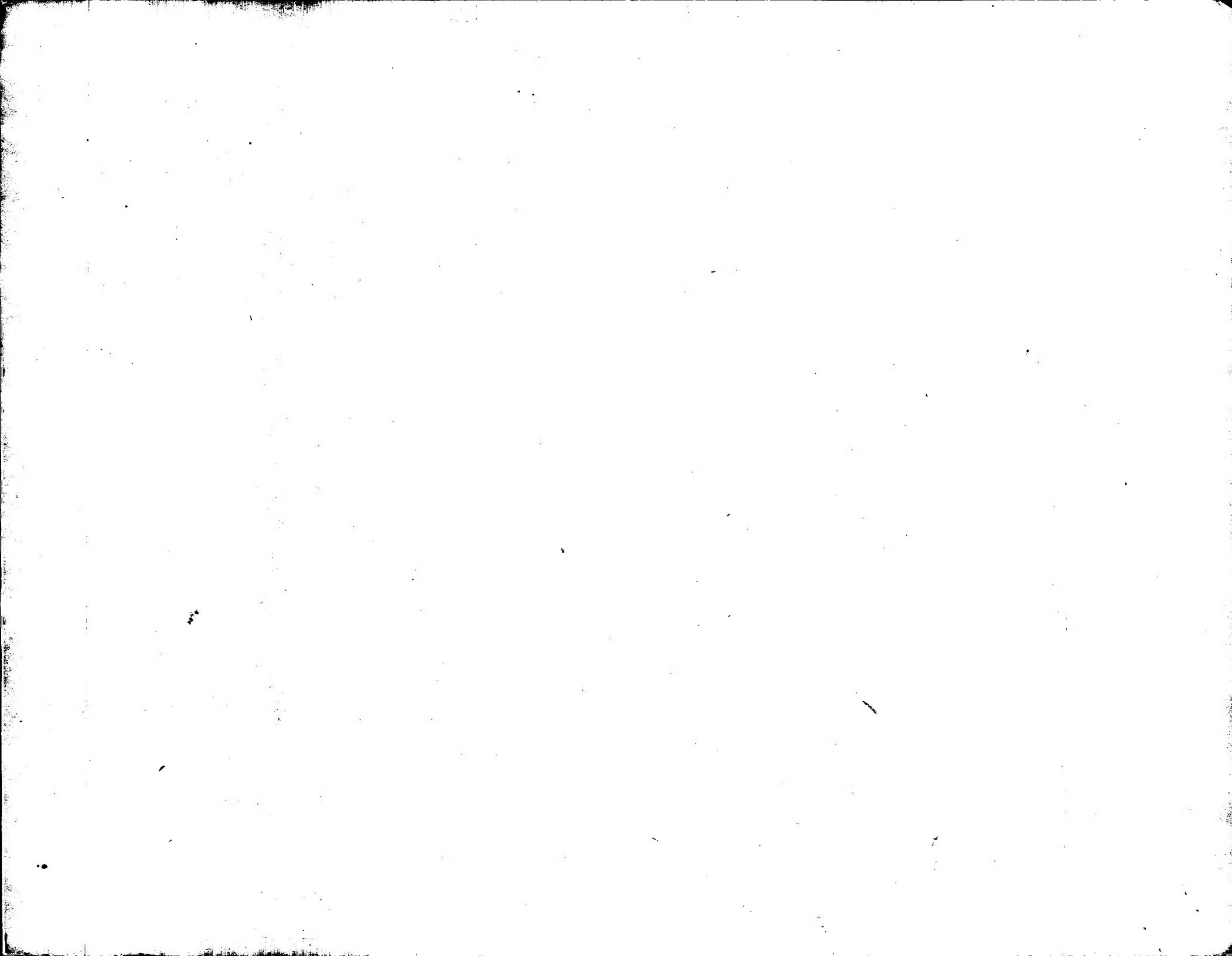
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Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	0.441	0.441	0.440	0.441		
B	1.745	1.755		1.747	1.747	1.750	1.748		
C	3.495	3.505		3.500	3.501	3.500	3.495		
D	1.745	1.755		1.748	1.747	1.750	1.748		
E	7.990	8.010		8.001	8.009	7.999	8.001		
F	0.490	0.510		0.499	0.498	0.498	0.498		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.357	0.344	0.377	0.377		
I	0.490	0.510		0.501	0.499	0.500	0.495		
J	1.174	1.184		1.177	1.177	1.179	1.177		
K	0.558	0.578		0.569	0.567	0.566	0.563		
L	1.174	1.184		1.177	1.178	1.179	1.177		
M	1.365	1.375		1.369	1.368	1.369	1.367		
N	2.495	2.505		2.499	2.498	2.499	2.499		
O	4.119	4.129		4.124	4.124	4.124	4.123		
P	0.115	0.135		0.129	0.128	0.121	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.245	0.244	0.247	0.250		
S	0.115	0.135		0.130	0.129	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.241	0.242	0.240	0.243		
W	0.115	0.135		0.124	0.125	0.127	0.130		
X	0.307	0.312		0.316	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.365	0.367	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.629	0.630	0.625	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.250	0.249	0.246	0.249		
AE	1.500	1.520		1.509	1.508	1.503	1.506		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.249	0.250	0.250		
AI	2.000	2.020		n/a	n/a	n/a	n/a		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	EP / J.G / J.L	Audited by:	JL
Date:	06/06/25	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JL



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Description: Saddle, Aft Inboard				Part Number:	D2574
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C	3.495	3.505		3.497	3.496	3.496	3.500		
D	1.745	1.755		1.748	1.749	1.750	1.745		
E	7.990	8.010		8.001	8.001	8.001	8.003		
F	0.490	0.510		0.497	0.496	0.500	0.499		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.498	0.495	0.496	0.500		
J	1.174	1.184		1.177	1.178	1.176	1.178		
K	0.558	0.578		0.565	0.560	0.563	0.563		
L	1.174	1.184		1.177	1.178	1.176	1.178		
M	1.365	1.375		1.368	1.368	1.366	1.367		
N	2.495	2.505		2.499	2.495	2.498	2.495		
O	4.119	4.129		4.122	4.119	4.121	4.121		
P	0.115	0.135		0.122	0.122	0.121	0.121		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.257	0.250		
S	0.115	0.135		0.122	0.120	0.121	0.120		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		0.242	0.243	0.237	0.236		
W	0.115	0.135		0.123	0.127	0.127	0.123		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.355	0.364	0.362	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.624	0.625	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.249	0.250	0.244		
AE	1.500	1.520		1.507	1.508	1.511	1.509		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.250	0.253	0.247	0.247		
AI	2.000	2.020		n/a	n/a	n/a	n/a		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

Accept/Reject

Measured by:	En	Audited by:	JML
Date:	06/06/20	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JML

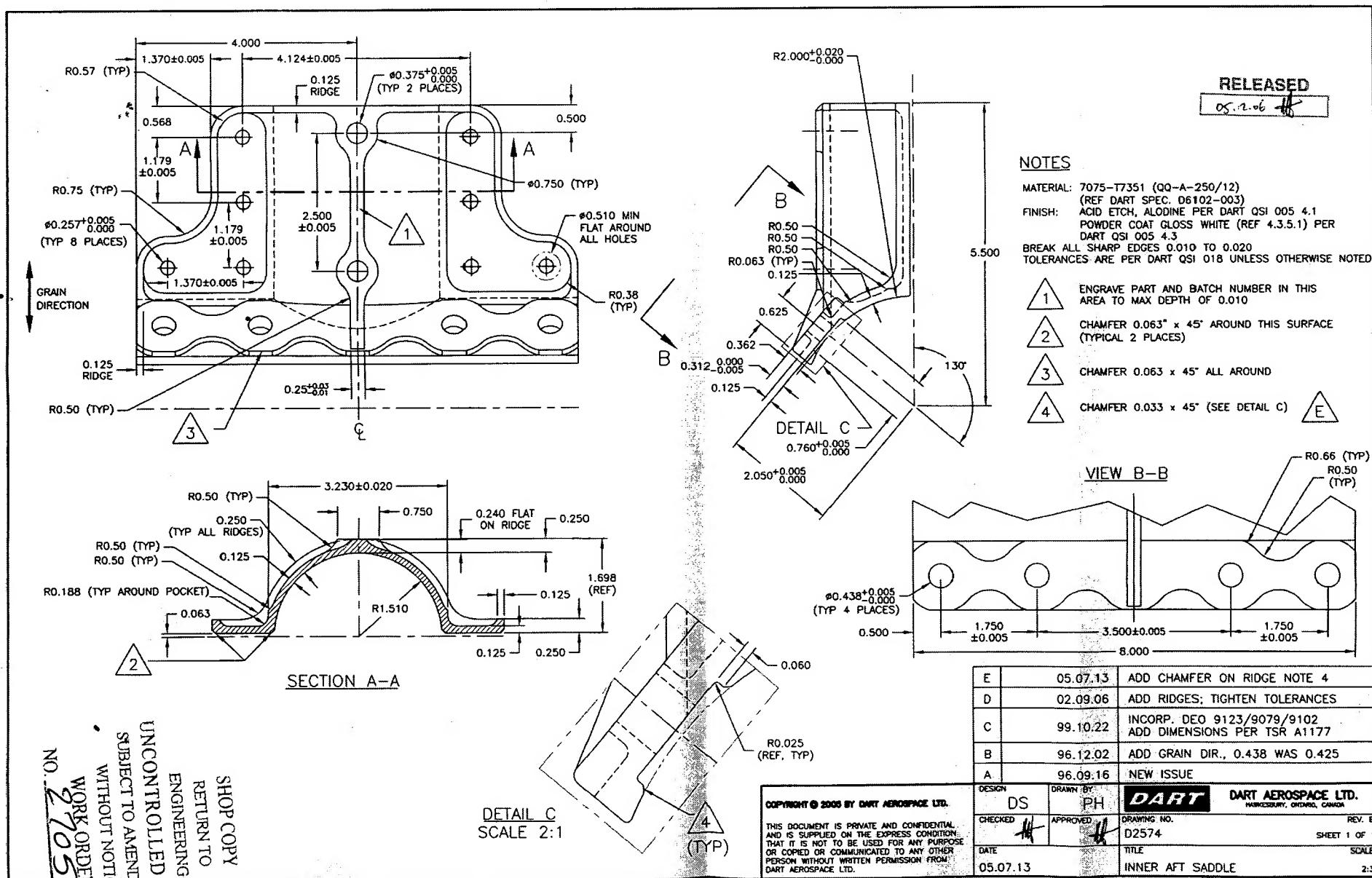
DART AEROSPACE LTD				Work Order:	27059
Description: Saddle, Aft Inboard				Part Number:	D2574
Inspection Dwg: D2574 Rev. E				Page 1 of 1	

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D	1.745	1.755		1.747	1.747	1.746	1.746		
E	7.990	8.010		7.999	7.999	7.998	7.999		
F	0.490	0.510		0.495	0.497	0.499	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
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K	0.558	0.578		0.563	0.567	0.569	0.569		
L	1.174	1.184		1.177	1.178	1.179	1.180		
M	1.365	1.375		1.365	1.368	1.366	1.367		
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Y	0.760	0.765		0.765	0.766	0.765	0.765		
Z	0.352	0.372		0.359	0.360	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.620	0.621	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.246	0.247		
AE	1.500	1.520		1.501	1.508	1.508	1.507		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.258	0.249	0.251	0.249		
AI	2.000	2.020		nl	nl	nl	nl		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EO / J.G	Audited by:	YML
Date:	06/07/02	Date:	06/07/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM



NO. 27059  
 WORK ORDER  
 ENGINEERING  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

